

(b) at least one scrap cutting blade secured to the base of the cutting die for cutting a piece of scrap from a sheet of corrugated board that is directed through a nip defined between the cutting die and the anvil;

(c) at least one scrap stripper mounted to the base adjacent the blade for stripping a cut scrap piece from the blade and for urging the cut scrap piece against the anvil as the cut scrap piece exits the nip;

(d) at least one scrap stripper being constructed of a resilient material and including a base, and a flexible finger integral with the base and extending outwardly over the base and at an acute angle with respect to the base such that an opening is defined between the angled finger and the base; and

(e) wherein the flexible finger is movable between a retracted position where the finger lies adjacent the base and an extended position where at least a portion of the finger is separated from the base.

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8. A method of cutting corrugated board passing between a rotary cutting die and an anvil, stripping one or more cut scrap pieces from a scrap cutting blade, and directing the cut scrap from the cutting die and anvil, comprising;

(a) directing a sheet of corrugated board through a nip area defined between the cutting die and anvil;

(b) cutting one or more scrap pieces from the corrugated board as it passes through the nip;

(c) utilizing a scrap stripper having a base and a flexible, angled finger to strip the cut scrap piece from the scrap blade and to control the direction of movement of the scrap piece as the scrap piece exits the nip, and wherein the flexible finger is integral with the base and extends

outwardly over the base at an acute angle with respect to the base such that an opening is defined between the angled finger and the base;

02 (d) compressing the scrap stripper between the cutting die and the scrap piece by bending and compressing the finger against the base, closing the opening existing between the angled finger and the base, and compressing both the finger and base as the scrap stripper moves through the nip;

(e) expanding the scrap stripper as the scrap stripper moves from the nip and engaging the cut scrap piece and stripping it from the scrap cutting blade; and

(f) extending the flexible finger outwardly as the scrap stripper moves from the nip and engaging the cut scrap piece with the extended finger and holding the cut scrap piece against the anvil with the finger such that the anvil tends to direct the cut scrap piece away from the nip and away from the cutting die and anvil.

14. The method of claim 8 wherein the angle formed between the base and the finger is approximately 30-75 degrees.

15. A rotary cutting die having one or more scrap strippers for stripping cut scrap pieces from one or more scrap cutting blades associated with the cutting die comprising;

03 (a) a board;

(b) at least one blade mounted on the board for cutting scrap;

(c) at least one resilient scrap stripper formed independently of the board and mounted on the board adjacent the scrap cutting blade for stripping a cut scrap piece from the blade; and

(d) the scrap stripper being constructed of a compressible material and including a base, an outer flexible portion extending outwardly over the base and at an acute angle with